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Approvals: **Process Plan:** DAS **Date:** OCT 17 2010 **Tooling:** _____ **Date:** _____ **Run** **Start** ***NR1***
 QC: 21 **Date:** _____ **SPC (Y/N):** _____ **Date:** _____ **Stop** ***NR2***
 9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3278	Rev C								
100		0.00							
100	SHEAR								
Bandsaw	Memo	0.55							
Jeaspa Bandsaw	Cut blank: 2.00" x 1.00" x 2.550" long								
						40	0		DAS 20 9-89 16-10-24
110		0.11							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.67							
HAAS CNC vertical machine #1	1- Machine as per Folio FA405 and Dwg D32782- Deburr and TumbleIdentify as D3278-2								
						40			DAS 44 9-89 16-10-28
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.07							
Quality Control									
						40			DAS 44 9-89 16-10-28
									DAS 33 9-89 16/10/29
									DAS 33 9-89 16/10/29

Work Order ID 151988

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Item ID: D3278-2 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Support
 Start Date: 10/21/2016 Start Qty: 40.00 ***40*** Cust Item ID:
 Required Date: 11/1/2016 Req'd Qty: 40.00 ***40*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.13				40	0		DAS 45 10-10-3 9-89
140 *140* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.07				(x40)	0		2016/11/02 BETB.
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M134798. Memo START TIME: 11:30 FINISH TIME: 12:00	0.00 0.00				40	0	16-11-02	DAS 34 9-89

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Item ID: D3278-2

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Support

Start Date: 10/21/2016 Start Qty: 40.00

40

Cust Item ID:

Required Date: 11/1/2016 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.07							
Quality Control									DAS 38 9-89 NOV 02 2016
170	Identify as per dwg & Stock Location: _____	0.00							
170									
Packaging	Memo	0.07							
Packaging	LOCATION : GA								40 DAS 6 9-89 NOV 03 2016
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.67							
Quality Control									16/11/8 JJ DAS 21 9-89 NOV 03 2016

Picklist Print

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Work Order ID: 151988

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Parent Item: D3278-2

D3278-2

Parent Item Name: Support

Start Date: 10/21/2016

Required Date: 11/1/2016

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP: A04.04.19New issueKJ/JLM
IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X02.00 0		Purchased	No			100	f	38.0100	0.2337	9.84			

M6061T6B1 000X02 000

6061-T6 Bar 1.00 x 2.00

9.042'

DAS
20 16-10-24
9-89

Location

Loc Qty

Loc Code

MAT

38.01

M134677

2.01

M135377

12

M135687

24

9.042'

DART AEROSPACE LTD		Work Order:	151988
Description: Support		Part Number:	D3278-2
Inspection Dwg: D3278 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.098	+0.005/-0.000	0.098	✓		Venn	FK-04
0.359	+/-0.005	0.359	✓		"	"
0.609	+/-0.010	0.612	✓		"	"
0.250	+/-0.010	0.253	✓		"	"
1.480	+/-0.005	1.480	✓		"	"
R0.125	+/-0.010	0.125	✓		R-G	
0.119	+0.005/-0.004	0.121	✓		Venn	FK-04
2.439	+/-0.010	2.441	✓		"	"
1.980	+/-0.010	1.980	✓		"	"
R0.13	+/-0.030	0.125	✓		R-G	
Ø0.257	+0.005/-0.000	0.258	✓		Venn	FK-04
R0.375	+/-0.010	0.375	✓		R-G	
0.875	+/-0.010	0.875	✓		Venn	FK-04
0.500	+/-0.010	0.500	✓		"	"
R0.400	+/-0.010	0.400	✓		R-G	
R1.00	+/-0.030	1.00	✓		"	
1.720	+/-0.010	1.722	✓		Venn	FK-04
R0.125	+/-0.010	0.125	✓		R-G	
0.125	+/-0.010	0.125	✓		Venn	FK-04

Measured by:	DAS 44 9-89	Audited by:	DAS 45 9-89	Prototype Approval:	N/A
Date:	16-10-28	Date:	16-10-31	Date:	N/A

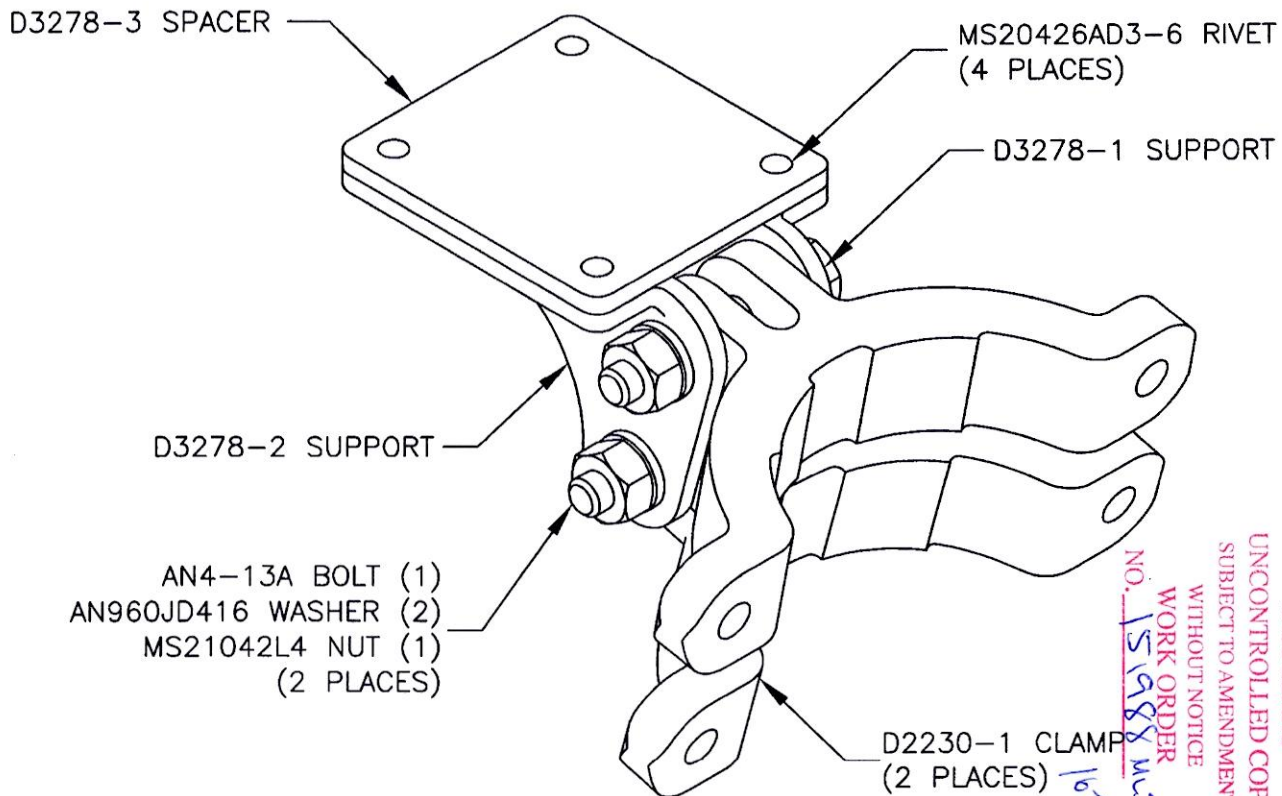
Rev	Date	Change	Revised by	Approved
A	04.04.19	New Issue P/O D3278-041	KJ/JLM	
B	05.06.08	0.359 was 0.365; 0.119 was 0.125	KJ/JLM	
C	07.09.26	Dimensions updated per Dwg Rev. C	KJ/EC	



DESIGN 97	DRAWN BY BC	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED B	APPROVED H	DRAWING NO. D3278	REV. C SHEET 1 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07-08-06

D3278-041 SUPPORT ASSEMBLY



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 151988 m57
161011

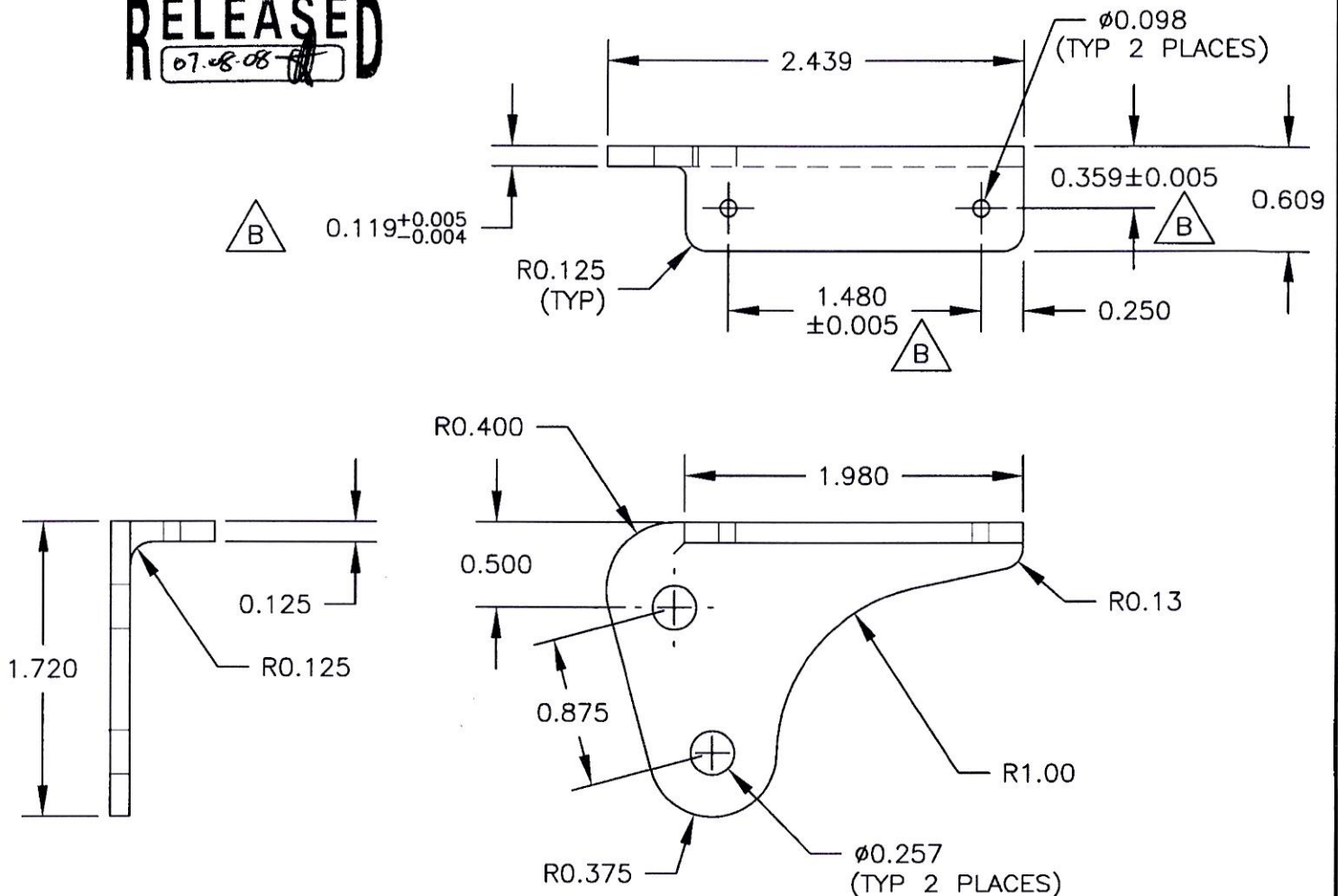
Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

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DESIGN <i>9P</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 2 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

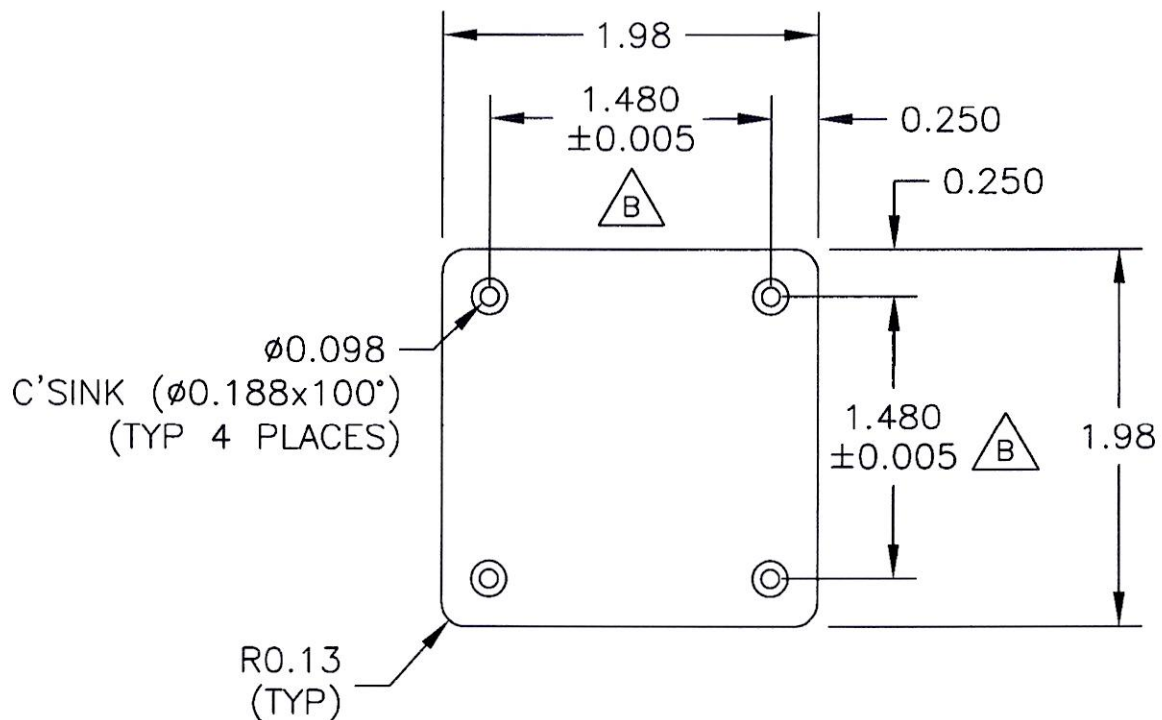
- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24	TITLE SUPPORT ASSEMBLY		SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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